

Date: Tuesday, 11/14/2006 10:07:49 AM  
 User: Kim Johnston

**Process Sheet**

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BLADE FITTING
<b>Job Number</b> :	29432		
<b>Estimate Number</b> :	12299		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3488041
<b>This Issue</b> :	11/14/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3488 / DSK101
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	28318	<b>Drawing Revision</b> :	B / D
	<b>Type</b> :	<b>Material</b> :	N/A
	MACHINED PARTS	<b>Due Date</b> :	12/15/2006
<b>Written By</b> :			<b>Qty:</b> 16
<b>Checked &amp; Approved By</b> :			<b>Um:</b> 20
<b>Comment</b> :	Each		
	Est Rev:A New Issue 06-02-28 JLM		
	Est Rev:B As per Rev B 06-03-30 JLM		

**Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6103003	alum billet
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Alluminum Round Billet D6103-003 Batch: 3070		
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
<b>Comment:</b> MORI SEIKI CNC LATHE LARGE 1-Turn as per Dwg DSK 101 & Folio FA625 2-Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA625 & Dwg D3488 2-Deburr		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/14/2006 10:07:49 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 29432

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F 07/02/19 16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YH/M.H 07/02/26 X 16

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

F.L/M.H 07/02/26 (B)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

YH 07/02/28 X 16

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert 19393

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

MS 07-03-28 (15)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/23 (15)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

YH 07-03-28 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 07/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:07:49 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 29432

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



16

Comment: FINAL INSPECTION/W/O RELEASE



07/03/26

Job Completion



U. 07-03-26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	29432
<b>Description:</b> Blade Fitting, LH		<b>Part Number:</b>	D3488-1
<b>Inspection Dwg:</b> D3488	<b>Rev:</b> B	<b>Page 1 of 1</b>	

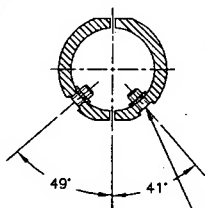
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.129	✓			
2.620	+/-0.010	2.620	✓			
0.793	+/-0.010	.795	✓			
1.351	+/-0.010	1.343	✓			
1.317	+/-0.010	1.316	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.801	✓			
Ø0.508	+0.006/-0.001	.511	✓			
R0.062	+/-0.010	5.062	✓			
1.500	+/-0.010	1.500	✓			
8.000	+0.030/-0.000	8.001	✓			
11.18	+/-0.030	11.172	✓			
Ø0.484	+0.005/-0.001	.487	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.149	✓			
3.070	+/-0.010	3.075	✓			
0.590	+/-0.010	.597	✓			
0.125	+/-0.010	.125	✓			
1.005	+/-0.010	1.006	✓			
3.500	+/-0.010	3.499	✓			
Ø0.297	+0.005/-0.000	.300	✓			
Ø0.430	+/-0.010	.432	✓			
0.100	+/-0.010	.098	✓			

<b>Measured by:</b> BC / J.L	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/02/18	<b>Date:</b> 07/02/18	<b>Date:</b>	N/A

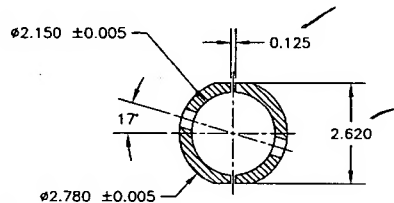
Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM [Signature]	[Signature]



SECTION B-B

Ø0.297  
C'BORE Ø0.430 x 0.100  
INSTALL ALS4-1032-225 (OR AKS4-1032-225  
OR ALS7-1032-225 OR AKS7-1032-225)  
INSERTS AFTER FINISH  
(4 PLACES)

4



SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

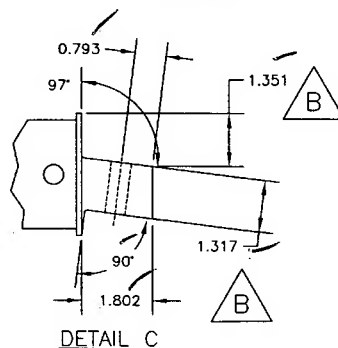
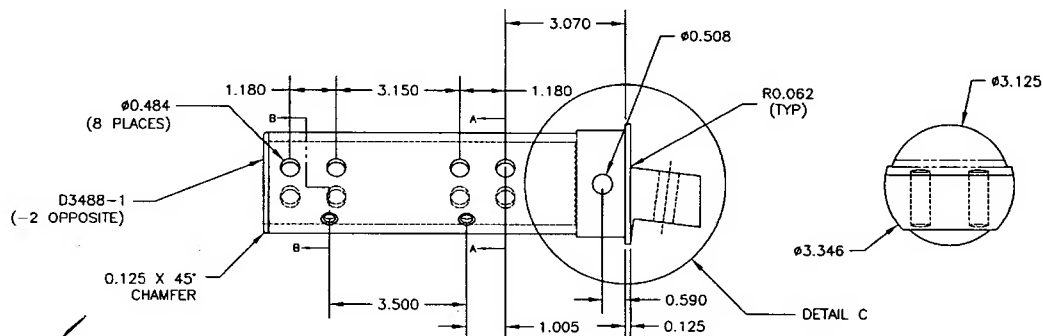
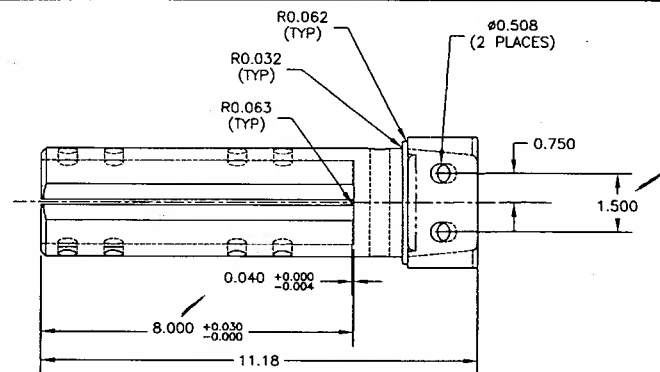
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR  
PER QQ-A-225/9  
(REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER  
29432

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ENGINEERING  
RETURN TO  
SHOP COPY



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED  
06.03.15 PH  
PER OS  
ELN #789

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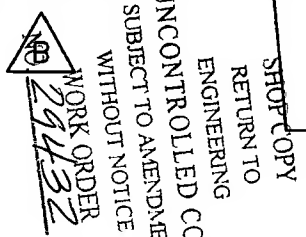
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B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED #	APPROVED #	DRAWING NO. D3488
DATE 06.03.15	TITLE BLADE FITTING	REV. B SHEET 1 OF 1 SCALE 1:3



**DART**

26-05-09 H



- DSK 101

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